

Date: Wednesday, 04/02/2009 12:40:04 PM
 User: Chantal Lavoie

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : STEP EXTRUSION
Job Number : 45494	
Estimate Number : 10058	
P.O. Number :	Part Number : D2622120C
This Issue : 04/02/2009 S.O. No. :	Drawing Number : D2622 REV C1
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : PURCHASED PARTS	Drawing Revision : C1
Previous Run : 44064	Material :
Written By :	Due Date : 23/02/2009 Qty: 120 Um: Each
Checked & Approved By : <u>C 209/02/04</u>	
Comment : Est. A: 02.11.12 New Issue KJ/RF	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PG	PURCHASING
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**Comment:** PURCHASINGIssue P/O: 3136C 209/02/04

- a) Extrude as per Dwg D2622 Rev. C
- b) Material: 6061-T6 (QQ-A-200/8)
- c) Minimum yield tensile strength = 35 ksi
- d) Minimum ultimate tensile strength = 38 ksi
- e) Minimum elongation = 8%
- f) Order at 120" longg) Bon L Canada Inc. tool # 897123 Rev. A
- h) To be packed per DSK 066
- i) Pull test to ASTM standard B221 required.
- j) Material certification is required

(120)

2.0	D2622120CP	Extrusion
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 120.0000 Each(s)
 Extrusion

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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**Comment:** PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage
 Ensure material certification is attached

4.0	QC6	DIMENSIONAL CHECK
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**Comment:** DIMENSIONAL CHECK

Inspect dimension per Dwg D2622
 Check Pull test per Dwg D2622 for compliance page attached
 Check hardness with Webster tester

C 209/02/13 (123)
209019 (123)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: STEP EXTRUSION

Job Number: 45494

Part Number: D2622120C

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

09/02/18 Hn
1-HALL # 008 → 97 HALL #007 → 26 = (123)

6.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/02/20

Job Completion



MF
09-02-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

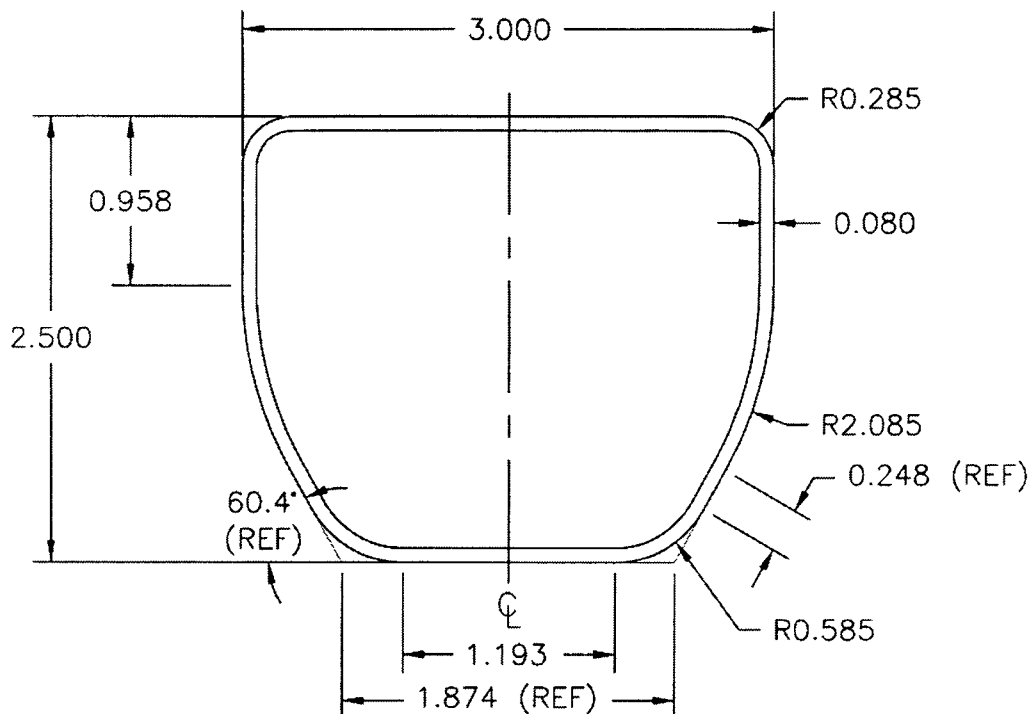
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries



DESIGN KE		DRAWN BY GP		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H		APPROVED H		DRAWING NO. D2622 REV. C SHEET 1 OF 1	
DATE 02.09.11		TITLE STEP EXTRUSION SCALE 1:1			
A	96.11.29	NEW ISSUE			
B	97.12.12	CHANGE MATERIAL, ADD TOL. QSI			
C	02.09.11	0.080 WAS 0.085; ADD PART & DIE No.			
CI	GP 02.10.04	ADD 'REV. A' TO DIE NUMBER			



1) PART NUMBER IS D2622-XXX WHERE 'XXX' IS CUT LENGTH IN INCHES
(EG. D2622-120 IS 120" LONG)

2) MATERIAL 6061-T6 (QQ-A-200/8)

3) MANUFACTURED USING BON-L DIE # 897123 REV. A CI

4) A SAMPLE FROM EACH BATCH WILL BE PULL TESTED TO ASTM STANDARD B221 BY AN APPROVED TESTING FACILITY TO ENSURE THAT THE BATCH MEETS THE MINIMUM MECHANICAL PROPERTIES STATED BELOW:

MINIMUM TENSILE YIELD STRENGTH = 35 ksi
MINIMUM ULTIMATE TENSILE STRENGTH = 38 ksi
MINIMUM ELONGATION = 8%

CL 09/02/04
W10: 45494

5) PART IS SYMMETRIC ABOUT CENTERLINE

6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

7) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



INVOICING COMPANY AND LOCATION
SIGNATURE ALUMINUM CANADA
500 EDWARD AVENUE
RICHMOND HIL ON L4C 4Y9

SHIPPING MANIFEST

MANIFEST DATE
02-13-09
MANIFEST NUMBER
654755
SALES ORDER NUMBER
43350

ACCT# 00046024

SHIP TO
DART AEROSPACE LTD.
1270 ABERDEEN ST.
HAWKESBURY ON
K6A 1K7 CN
PHONE 613-632-5200

SOLD TO / PURCHASER
DART AEROSPACE LTD.
1270 ABERDEEN ST.
HAWKESBURY ON
K6A 1K7 CN
PHONE 613-632-5200

TERMS / FREIGHT
O / P

REFER TO
THESE NUMBERS ON
ALL CORRESPONDENCE

CREDIT REP
HAMBROOK, PAU
905-508-3250

SALES REP
CUST SERVICE REP
Burton D
905-427-2227

CUSTOMER ID 46024
ORDER DATE 02/04/09
CUSTOMER PO NUMBER 8136

LOCATION RIH
TRAILER NUMBER 57393
SALESMAN 59358
FIELD SALES REP Kutter A
450-435-6551
JOB
BILL OF LADING NUMBER 08388777

U6388111											
ITEM NO.	ORIGINAL ORDER QUANTITY	UNIT	PREVIOUS SHIPPED QUANTITY	MFG. PART NUMBER	ALLOY & TEMPER	FINISH DESCRIPTION	NBR OF PKGS	THIS SHIPMENT		UNIT	QUANTITY DUE
				CUSTOMER PART NUMBER	LENGTH	FABRICATION DESCRIPTION		GROSS POUNDS	NET QUANTITY		
					CUTTING TOLERANCE	SHIPPING TOLERANCE					
01	121	KG	0	DAA-897123-1	6061 /T6	MILL	3	531	505	KG	
		M	0	D2622	120"	CERTIFICATE OF COMP			374.91	M	
		PC	0		+3/16 "	(+015-015,0139-0102)			123	PC	
					-0 "						
				LOT/TKT DETAIL:		43350010 / 204600	1	181	171		42 P
						43350010 / 204602	1	169	161		39 P
						43350010 / 204603	1	181	173		42 P
p3me											

CERTIFICATE OF COMPLIANCE

SIGNATURE ALUMINUM CANADA

500 EDWARD AVENUE
RICHMOND HILL, ON L4C 4Y9

Cert Date	Cert No	Sales Order	Page #
02/13/09	187328	43350	1
Dist No	B/I No	Lot	Date
8136	08388777	43350010	2/13/09

Sold To	Ship To
46024 DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7	46024 DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7

Item No	Part No	Item Description	Cust Part
1.000	DAA-897123-1	120" Mill 6061 T6	D2622

Gross Weight	531 KGS
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Net Qty	505 KG	123 PC	375 M	3 PKG
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Specification	Die Desc
AMS-QQ-A-200/8 & ASTM B221-08	

Mechanical Tests:

Test No.	Tensile MPA / KSI	Yield MPA / KSI	%Elongation	Conductivity	Bend/ Drift HREW
1	326.9 / 47.4	250.4 / 36.3	10.4	.0	93

Chemical Analysis:

SI	FE	CU	MN	MG	CR	NI	ZN	GA	V	TI	ZR	OTHER
.66	.27	.23	.07	.88	.05	.006	.05	.000	.009	.02	.000	.00

This will certify that the material described herein has been inspected and tested in accordance with Signature Aluminum Canada's standard sampling and testing procedures or in accordance with the requirements of any specification forming a part of the material description to the extent indicated herein. Data of chemical composition for the material and test results from samples representative of the material are set forth above hereof or in any attachments hereto. This information shows that the material meets the applicable requirements. Inspection and test records are maintained on file. This certificate shall be deemed apart of and subject to the terms and conditions of warranty set forth on the reverse side of our order acknowledgment form. No other warranties are applicable.

D. VanBakel, QA Manager Signature Aluminum Canada Inc